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Dart Aerospace Ltd.
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Tel (613) 632-5200

D3914-041
Job Sheet 174794



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/21/18	4/21/18	0.00	0.00	Start Up Large Fab-5	0.71	5042562
100	Large Fab	1 pcs	4/21/18	4/21/18	0.00	6.67	Large Fab 1		5053024
110	QC	1 pcs	4/21/18	4/21/18	0.00	0.00	QC9		5054823
120	QC	1 pcs	4/21/18	4/21/18	0.00	0.00	QC5		5052892
130	Powdercoat	1 pcs	4/21/18	4/21/18	0.00	0.40	Powdercoat4		5053639
135	QC	1 pcs	4/21/18	4/21/18	0.00	0.00	QC3		5050470
140	HandFinish	1 pcs	4/23/18	4/23/18	0.00	0.80	HandFinish3		5042813
150	QC	1 pcs	4/23/18	4/23/18	0.00	0.00	QC3		5050040
160	Packaging	1 pcs	4/23/18	4/23/18	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea	4/23/18	4/23/18	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M 136700 START: 1255 O.V.T: 320° FINISH: 1:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5042562
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5053024
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5054823
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5052892
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5053639
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5050470
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5042813
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5050040

3/21/18

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	54	0
	D3914-1	2	11	0
	D3914-7	2	10	0
	D4016-3	3	58	0
	D4018-5	9	21	0
	D4020-5	1	9	0
	D4021-3	1	7	0
	D4035-043	2	10	0
Part Specifications				
Specifications could not be found.				

Plex 3/21/18 1:34 PM Dart.Gagnon.Michelle

Master Unit 002080



Job No 174794



Container No: S062040



Part: D3914 - 041

Job No: 174794

Serial No/Batch: S062040

Revision: A/D

Inspector:

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